



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

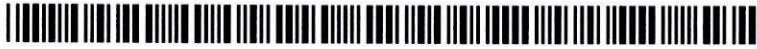
RBW6205G12731-3G
Job Sheet 177007



Part No: RBW6205G12731-3G

Job Qty: 2 ea

Part Name: Upper Plate Assembly



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 5/4/18

Job Tracking No:

Due Date: 6/8/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6205G12731-3G REV 3 IPP REV A 18.02.15 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		6/8/18	0.00	0.00	Start Up Container		
100	Purchasing	2 pcs		6/8/18	0.00	0.00	Purchasing		At 18/06/07
110	Packaging	2 pcs		6/8/18	0.00	0.00	Packaging2		At 18/06/07
120	QC	2 pcs		6/8/18	0.00	0.00	QC6		18-06-18-06-11
130	Packaging	2 pcs		6/8/18	0.00	0.00	Packaging3		21 JUN 25 2018
140	QC21-SA	2 Ea		6/8/18	0.00	0.00	QC21		GA 103.

Part Op 100 - 1- Issue P/O to Arrow Tech Machine Works P/O# 039026. 2- Manufacture RBW6205G12731-3G as per Descriptions: DWG 3- Certificate of conformity is required

08 Mai 2018 x 2 P. L.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G12731-3GP	Upper Plate Assembly	2 Ea (1 ea)	90-Start up Operation	5078952

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBW6205G12731-3GP	2	0	0

Part Specifications

Specifications could not be found.

Plex 5/4/18 10:35 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only

Work Order:		DISPOSITION				AGAINST DEPARTMENT/PROCESS															
Part No.		Rework	Scrap	Use-as-is	Suspected Unapproved	Skid-tube	Machining	Thermoforming	Large Fab	Cross tube	Small Fab	Finishing	Composite	Water Jet	Prod. Eng. Coord.	Rec/Store/Packaging	Supplier	Engineering	Quality	Other	
NCR No.																					
Date:		Step #:				QTY Effective:															MRB (QS1042) Approval
Description Work Order Deviation																					
Completed By																					
Lead hand / Supervisor Approval Verification																					
QC / QA Coordinator Approval																					
Root Cause																					
Environment																					
Design																					
Doc/Data																					
Equip/Tooling																					
Handling/Pre																					
Material																					
Internal Transport																					
Tribal Knowledge																					
LOA																					
Substation																					
Past Expiry Date																					
Misidentified																					
No Re-verification																					
Operator																					
Offset/Setup																					
Supplier																					
Training																					
Use for Testing																					
Poor Information																					
Rushing																					
Product Improvement																					
Process Improvement																					
Manufacturing Process																					
Past Due																					
OTHER:																					
Heat Treat																					
Wave/Twist in Tube																					
Marks/Chatter																					
Counter sink																					
Cut Too Short																					
Instructions Incomplete/Unclear																					
Drill Holes																					
Wrong Stock Pulled																					
Out of Sequence																					
Off-set																					
Mislabeled																					
Fit/Function																					
Misaligned/off center																					
Positioned Wrong																					
Outside Dimensions																					
Over/Under tolerance																					
Part Incorrect																					
Part Lost/Missing																					
Part Moved																					
Drawing																					
Finish																					
Misread																					
Turning Sequence																					

Dart Aerospace Ltd.
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CANADA
TEL: 1 813 632-5200
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Container No: S079012

Part: RBW6205G12731-3G

Job No: 177007

Serial No/Batch: S079012

Revision: 3

Inspector:

Exp Date:

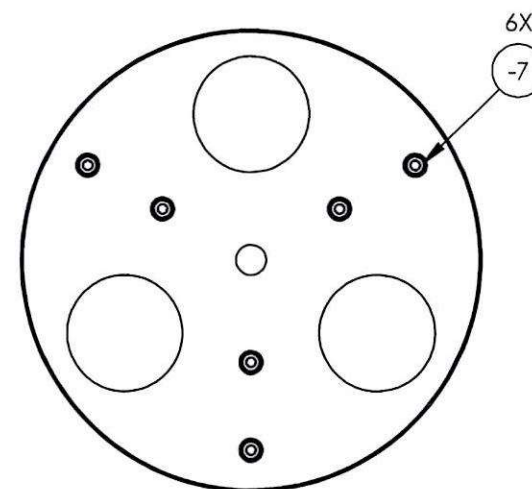
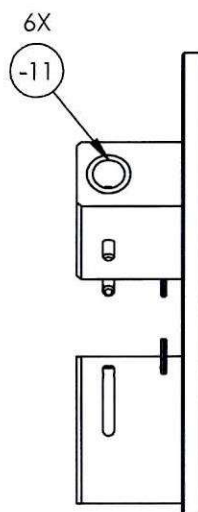
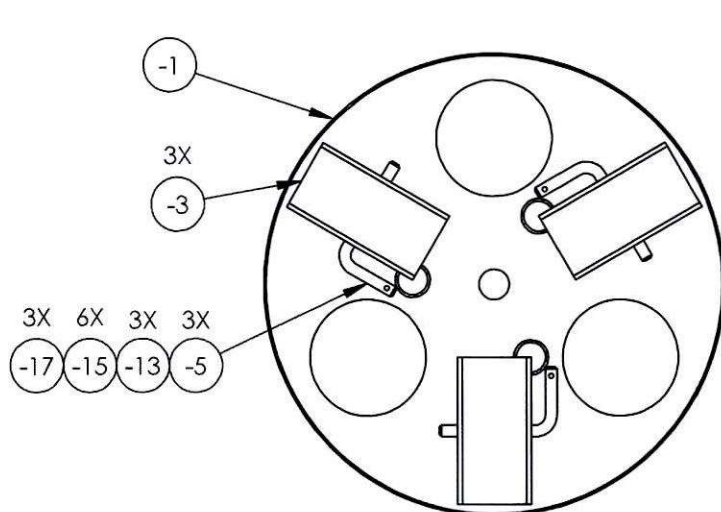
Instructions:

06/07/2018

Date: 06/07/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 ADDED ENGRAVE ASSY. T/N NOTE. -3 CH'D HOLE FROM $\varnothing .3125 \pm .005-.000$ TO $\varnothing .3150 \pm .005-.001$ & CH'D P.F. -40 TO P.F. -11, CORRECTED ENGRAVE NOTE P/N. -5 CH'D MATERIAL OVERALL LENGTH, ADDED MISSING DIM.	1/20/2011	RJC	RW
1A		-9 DELETED FROM BOM, NOT USED.	5/24/2011	RJC	RW
2		-1 ADDED MISSING DIM. $\varnothing .820$ FOR HOLE IN CENTER.	7/8/2011	RJC	DW
3		-3 CH'D $\varnothing .3125$ TOLERANCE FROM $+.005-.000$ TO $\pm .001$, ADDED MISSING DIMS TO LOCATE HOLES.	4/15/2013	CFS	GE



NOTE:

1. REF. AGUSTA T/N: 3G6205G11331.
2. PART OF KITS RBW6205G11231-3G AND RBW6205G13831-3G.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	PLATE	6061		2
			-3	3	BLOCK	6061		3
			-5	3	PIN	1018 G&P		4
		B/O	-7	6	SOCKET HEAD CAP SCREW	STEEL	M8 X 1.25 X 25mm (MCMASTER-CARR #95263A633)	1
		B/O	-11	6	BUSHING	STEEL	$\varnothing 22$ mm I.D X $\varnothing 30$ mm O.D. X 36mm (MCMASTER-CARR#8486A78)	1
		B/O	-13	3	SPLIT RING	STEEL	$\varnothing .80$ I.D. X $\varnothing .07$ WIRE (MCMASTER-CARR #86805T36)	1
		B/O	-15	6	FERRULE	ALUMINUM	$\varnothing 1/16$ X 3/8 MCMASTER-CARR #3896T31	1
		B/O	-17	3	LANYARD CABLE	COATED STEEL	$\varnothing 1/16$ X 6 (CARR LANE #CL-2-C)	1

DART AEROSPACE	
TITLE UPPER PLATE ASSEMBLY	
DWG NO. RBW6205G12731-3G	REV 3
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: CLOUGH APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL AGUSTA
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:5	DATE 4/30/2010 SHEET 1 OF 4



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039826

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO039826

PO Date: 5/8/18

Due Date: 6/4/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lussier, Patrick

Pynt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
MAY 07 2018

Ship To:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1		RBW6205G11451-3GP	Clamp As Per Dwg RBW6205G11451-3G Rev. 1	Firmed	6/4/18	16 Ea	0 Ea	16 Ea	\$83.64/Ea	\$1,338.24
Line Item Note W/O 177012										
2		RBW6205G13231-3GP	Arm Assembly As Per Dwg RBW6205G13231-3G Rev. 1	Firmed	6/4/18	6 Ea	0 Ea	6 Ea	\$413.50/Ea	\$2,481.00
Line Item Note W/O 177008										
3		RBW6205G12731-3GP	Upper Plate Assembly As Per Dwg RBW6205G12731-3G Rev. 3	Firmed	6/4/18	2 Ea	0 Ea	2 Ea	\$2,595.37/Ea	\$5,190.74
Line Item Note W/O 177007										

Grand Total: \$9,009.98

Order Notes

re'd 11/14/18/07

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 5/8/18 11:39 AM dart.Lussier.Patrick



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No:039826

Dated: 6/5/2018

Our Order / Job No:039826-3AWT

Order Qty:2

Part Name: UPPER PLATE ASSEMBLY

Part Number:RBW6205G12731-3G

Lot Size:N/A

Ship Date: 6/5/2018

PD 18-06-11

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number:6205G12731-3G

Rev: 3

Material Size and Type: -1/6061 ALUM.; -3/6061 ALUM; -5/1018 STEEL

Material Specifications: ALUM: ASTM B221; STEEL: ASTM A108, ASTM A29

Heat Treatment: N/A

Plating/Finish: CLEAR ANODIZE: MIL-A-8625F, TYPE II, CLASS I;ZINC PLATE: ASTM B633, TYPE 1, SC 2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date:

06/05/18

Signed:

[Signature]

PHGE Machine Works LLC dba Arrow Tech Machine Works

29751 E. Enid Rd. Unit C Eugene, Oregon 97402

Main: (541) 780-6938 | Fax: (458) 215-4938

www.atechmachineworks.com